



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 173609



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Due Date: 7/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		7/18/18	0.00	0.00	Start Up Large Fab-4		S.L.H.
110	Large Fab	10 pcs		7/19/18	0.00	9.91	Large Fab 2		S.L.H.
120	QC	10 pcs		7/19/18	0.00	0.00	QC9		CPL
130	QC	10 pcs		7/19/18	0.00	0.00	QC5		CPL
140	HandFinish	10 pcs		7/19/18	0.00	1.84	HandFinish1		SA18-04-26
150	QC	10 pcs		7/19/18	0.00	0.00	QC7-2		7
180	Large Fab	10 pcs		7/19/18	0.00	9.91	Large Fab 2		S.L.H.
190	QC	10 pcs		7/19/18	0.00	0.00	QC10		CPL
200	QC	10 pcs		7/19/18	0.00	0.00	QC5		CPL
210	HandFinish	10 pcs		7/19/18	0.00	1.84	HandFinish1		SA18-05-07
220	Powdercoat	10 pcs		7/19/18	0.00	2.90	Powdercoat1		BL-13-5-07
230	HandFinish	10 pcs		7/20/18	0.00	1.84	HandFinish3		SEB-05-08
240	QC	10 pcs		7/20/18	0.00	0.00	QC3		MAY 10 2018
250	Packaging	10 pcs		7/20/18	0.00	0.00	Packaging1-3		MAY 09 2018
260	QC	10 pcs		7/20/18	0.00	0.00	QC4		DAS
265	DC	10 pcs		7/20/18	0.00	0.00	DC		58
270	Packaging	10 pcs		7/20/18	0.00	0.00	Packaging3-1		9-80
280	QC21-FG	10 Ea		7/20/18	0.00	0.00	QC21		MAY 10 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M38673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 8:30 OVEN TEMPERATURE: 320 FINISH TIME: 11:00

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

H7x01x10xLH
5062824x10xLH

2910 wing walk M38851

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	9049922
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	9050520
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	9059469
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	9059498
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	9051986
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	9041171
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	9047824
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	9062374
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	9048292
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	9051388x6 9060272 x34
D2618	Bushing	20 Ea (2 ea)	250-Packaging	9049859
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging	9046950
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	9053650 905314 x16 9053650
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	9059873x6 9067910x4 x68
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	9068535x4 9068536x12 9054168
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	9068536x12 9054168
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	9041169
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	9068537x8 9015269
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	9068540x24 9055952x136
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	9068541x8 9039036x32

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	41	0
	D3219-1	20	55	0
	D3272-1	10	0	0
180-Large Fab	D3065-041	10	22	0
	D3066-1	20	10	0
	MS20600-AD4W4	160	1,681	0
250-Packaging	AN3-35A	20	312	0
	AN4-13A	80	941	0
	AN5-36A	20	148	0
	D2230-3	40	65	0
	D2618	20	214	0
	D2856-400-720	20	197	0
	D3235-1	20	6	0
	D3278-041	10	7	0
	MS21042L3	20	3,284	0
	MS21042L4	80	3,884	0
	MS21042L5	20	849	0
	NAS1149D0363J	40	3,378	0
	NAS1149D0463J	160	5,081	0
	NAS1149D0563J	40	1,290	0

Part Specifications

Specifications could not be found.



Container No: S062824



Part: D350-591-311

Job No: 173609

Serial No/Batch: S062824

Revision:

Inspector:

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Plex 3/5/18 4:04 PM Dart.Gagnon.Michelle

3118

Date: 04/19/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003118	S051382	D2230-3	Mounting Lug	S051380	ST521	6
003118	S069776	D2230-3	Mounting Lug	S066272	ST521	34
003118	S069746	D2618	Bushing	s049859	ST008	20
003118	S069745	D2856-400-720	Abrasion Strip 4" X 7.20"	s046950	ST418	20
003118	S051314	D3235-1	Mounting Lug	S051313	ST522	17
003118	S069744	D3235-1	Mounting Lug	S053650	ST522	3
003118	S059873	D3278-041	Support Assembly	S060378	ST522	6
003118	S069743	D3278-041	Support Assembly	S067940	ST522	4
003118	S068535	MS21042L3	Nut	S063597	Start Up Stores/Pkg-1	8
003118	S069742	MS21042L3	Nut	s062377	GA011	12
003118	S068536	MS21042L4	Nut	S064841	ST303	12
003118	S069741	MS21042L4	Nut	s054118	ST303	68
003118	S069740	MS21042L5	Nut	s041167	ST303	20
003118	S068539	NAS1149D0363J	Washer	S064841	ST263	8
003118	S069739	NAS1149D0363J	Washer	s015269	ST263	32
003118	S068540	NAS1149D0463J	Washer	S064841	ST263	24
003118	S069738	NAS1149D0463J	Washer	s055952	ST263	136
003118	S068541	NAS1149D0563J	Washer	S064715	ST263	8
003118	S069737	NAS1149D0563J	Washer	s039036	ST263	32

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 5/9/18 11:30 AM dart.quirion.sonia

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY